

5/42

DART AEROSPACE LTD		Work Order:	24335
Description: Guide		Part Number:	D3112-1
RF 04.11.29 Drawing: D3112 Rev. A T B		Qty:	5
RF 02.11.14			6

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order	DA	05.09.26	5
2	METAL /CNC-CELL	Cut blanks: 0.625" x 1.500 bar x 2.625" long. Material: 6061-T6/T6511/T651 ( QQ-A-225/8 OR QQ-A-20078) Bar ref DART spec M6061T6B Batch M17037	SP	05/10/26	6
3	HAAS	Machine as per Folio FA233 Note: Engrave / scribe DART P/N on part as per dwg.	J.L	05.10.26	6
4	QC	Inspect Level 2	J.L	05.10.26	6
5	QC	Inspect Level 8	EP	05.10.26	6
6	METAL/CNC-CELL	Deburr break all unmarked sharp edges .005 to 0.010	J.L	05.10.26	6
7	QC	Inspect Level 5	EP	05/10/26	6
8	FINISHING	Chemical conversion coat as per QSI 005 4.1	SAD	05/11/26	6
9A	FINISHING	Powder coat grey sandtex ( 4.3.5.6 ) per QSI 005 4.3.	SP	05/11/26	6
9B	QC3	Inspect work to step 9A			
10	STORES	Identify and stock Loc 64 with P/N & B/N using fine point permanent ink marker	10	05/11/26	6
11	EXPEDITING	Close W/O Inspect level 21 Cost/part 154c 05/11/26	(6)	05/11/26	6

Rev	Date	Change	Revised By	Approved
A	02.05.22	New Issue	NG	02.05.22

RELEASED

02/05/22

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes

No

DQA:

Date: 05/11/28

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

DART AEROSPACE LTD	Work Order:	24335
Description: Guide	Part Number:	D3112-1
Inspection Dwg: D3112	Rev: B	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	JL	Audited by:	ognl	Prototype Approval:	N/A
Date:	05/10/26	Date:	05/10/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.07.07	New Issue	KJ/JLM	<del> </del>

RE-  
RELEASED  
10/15/88-11



DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED 	APPROVED 	DRAWING NO. D3112	REV. B	SHEET 1 OF 1
DATE 04.10.18		TITLE GUIDE	SCALE 1:1	
A	02.04.12	NEW ISSUE		
B	04.10.18	ADD PART MARKING; $\phi 0.191$ WAS $\phi 0.185$		

RELEASER  
04.11.23

R0.125

(TYP)

R0.125

(TYP)

B

DRILL #11 ( $\phi 0.191$ )

- R0.313 (TYP)

Technical drawing showing a part with a central hole and a slot. The part is supported by four legs. The top surface has two radii of 0.125 (TYP). The central hole has a diameter of 0.191 (TYP). The slot has a width of 0.191 (TYP) and a depth of 0.063 (TYP). The part has a total height of 2.500, with a 2.000 segment above a 0.500 segment. The slot is located 0.412 (TYP) from the top edge. The central hole has a diameter of 0.191 (TYP). The part is supported by four legs with a height of 0.155 and a width of 0.250. The base has a width of 1.000 and a height of 0.500. The base is supported by four legs with a height of 0.125 and a width of 0.500.

**D3112-1 GUIDE**

QUIP-COPY

RETURN TO  
ENGINEERING

8) ENGINEERING  
UNCONTROLLED COPY  
AMENDMENT

## WORK ORDER

NO. 24335

**NOTES:**

**NOTES:**

- 1) MATERIAL: 6061-T6/T6511/T651 (QQ-A-225/8 OR QQ-A-200/8)  
BAR (REF. DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3.1  
SIGHT TO AMENDMENT  
WITHOUT NOTICE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) POSSIBLE SUPPLIER: PREMIER P/N B30-23000-17
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

UNCONTROLLED COPY  
WORK ORDER  
NO. 24335

Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Sep 26, 2005  
10:48 am

Work Order No : 0024335  
 Project Name : D3112-1  
 Project For : WK542  
 Work Order Type : Main  
 Main WO Number :  
 House Part Number : D3112-1  
 Description : Guide  
 Manufactured : Yes  
 Amount Req'd : 5  
 Amount Done : 0  
 Start Date : 09-26-05  
 Est Finish Date : 10-12-05  
 Act Finish Date :  
 Drawings Reqd : No  
 Ok for Approval :  
 Approval Rec'd :  
 Department Code:  
 Burden Flags : NNNNNNN  
 WO Status : Open  
 Invoice State : Not Invoiced  
 Invoice Date :  
 Invoice Number :  
 Invoice Amount : 0.00  
 Order Entry No :  
 OE Value : 0.00  
 Est Mark Up : 0.000%  
 Actual Mark Up : 0.000%  
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden :	0.00	0.00	0.00		
<hr/>					
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00

## Job Costing Report

Dart Aerospace Ltd.  
HawkesburyNov 08, 2005  
11:17 am

Work Order No : 0024335  
 Project Name : D3112-1  
 Project For : WK542  
 Work Order Type : Main  
 Main WO Number :  
 House Part Number : D3112-1  
 Description : Guide  
 Manufactured : Yes  
 Amount Req'd : 5  
 Amount Done : 0  
 Start Date : 09-26-05  
 Est Finish Date : 10-12-05  
 Act Finish Date :  
 Drawings Reqd : No  
 Ok for Approval :  
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:  
 Burden Flags : NNNNNNN  
 WO Status : Open  
 Invoice State : Not Invoiced  
 Invoice Date :  
 Invoice Number :  
 Invoice Amount : 0.00

Order Entry No :  
 OE Value : 0.00

Est Margin : 0.000%  
 Actual Margin : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	5.00	100.00		
Production Cost :	0.00	84.85	100.00	0.00	84.85
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	5.00	100.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden :	0.00	0.00	0.00		
<hr/>					
Total Cost :	0.00	84.85	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	84.85			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	( -84.85)

Date: Monday, 14/11/2005 8:37:45 AM  
 User: Alba Panzuto

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: GUIDE		
Job Number	: 24335					
Estimate Number	: 10367					
P.O. Number	:			Part Number	: D31121	
This Issue	: 14/11/2005		S.O. No. :	Drawing Number	: D3112 REV B	
Prsht Rev.	: NC			Project Number	:	
First Issue	: / /		Type :	MACHINED PARTS	Drawing Revision	: B
Previous Run	:			Material	:	
Written By	:			Due Date	: 30/11/2005	
Checked & Approved By	:			Qty:	5 Um: Each	
Comment	: Est. A 02.05.22 New Issue NG					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0750X00125	6061-T6 Bar .75" x .125"	
2.0	BAND SAW	BAND SAW	
Comment:	BAND SAW	Cut blanks: 0.625" x 1.500 bar x 2.625" long.	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
Comment:	HAAS CNC VERTICAL MACHINING #1	Machine as per Folio FA233	
		Note: Engrave / scribe DART P/N on part as per dwg.	
		Deburr break all unmarked sharp edges .005 to 0.010	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment:	INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC8	SECOND CHECK	
Comment:	SECOND CHECK		
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
Comment:	HAND FINISHING RESOURCE #1	Chemical Conversion Coat as per QSI 005 4.1	

## Process Sheet

<b>Customer:</b> CU-DAR001 Dart Helicopters Services		<b>Drawing Name:</b> GUIDE
<b>Job Number:</b> 24335		<b>Part Number:</b> D31121
Job Number:		
<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
7.0	POWDER COATING	POWDER COATING
		
<b>Comment:</b> POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3		
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		
<b>Comment:</b> INSPECT POWDER COAT/CHEMICAL CONVERSION		
9.0	PACKAGING 1	PACKAGING RESOURCE #1
		
<b>Comment:</b> PACKAGING RESOURCE #1 Identify with P/N and B/N using a permanent fine point marker, then Stock Location: _____		
10.0	DC	DOCUMENT CONTROL
		
<b>Comment:</b> DOCUMENT CONTROL Inspection Level 21		
Job Completion		